

43

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	21607
<b>Description:</b> Wearplate	<b>Part Number:</b>	D2577-7
<b>Dwg:</b> D2577 Rev. E	<b>Qty:</b>	21 20
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <b>Dwg not required</b>	HJ	04.09.29	20
2	PG	Issue P/O: 2006904 <b>Email or Ship DXF file to vendor</b> Laser Cut per Dwg D2577 flat pattern D2577-7 <b>Material release note required</b>	W	04.09.29	20
3	RG	Receive and Inspect for transit damage <b>Ensure that material release note is attached</b>	C2	04/10/13	21
4	QC6	Inspect dimensions per template D2577-7T1	B	04.10.20	21
5	GB	Deburr if necessary	B	04.12.06	21
6	GB	Form on brake using DT8155 and DT8179 as per Dwg D2577 <b>Identify as D2577-7</b>	Z	04.12.06	21
7	GB	Form joggle as per Dwg D2577 using DT8157.	Z	04.12.06	21
8	QC5	Inspect work to Step 7	B	04.12.20	21
9	FP	Powder Coat Grey (Ref.4.3.5.6) per QSI 005 4.3	M	05.03.17	21
10	QC3	Inspect Powder Coat	C2	05/03/17	21
11	FP	Identify and Stock	M	05.03.17	21
12	AC	Cost / part 14.30	S95	05.02.28	21
13	DC	Close W/O 13.94 Inspect Level 21	HJ	05.04.05	21

Rev	Date	Change	Revised By	Approved
A	96.08.20	New Issue		
B	98.10.15	Bending now in-house	KS	
C	99.02.02	Changed Powder Coat	DM	
D	00.04.10	Added ref. QSI 034	EC	
E	00.10.02	Rev.E dwg	EC	
F	02.09.24	Re-format	KJ RF	

RELEASED  
02/10/02 RF

**Dart Aerospace Ltd**

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**NOTE:** Date & initial all entries  
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Sep 28, 2004  
04:07 pm

Work Order No : 0021607  
Project Name : D2577-7  
Project For : WK443  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2577-7  
Description : Wearplate  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 09-28-04  
Est Finish Date : 10-21-04  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



New Zealand Steel Limited  
 Glenbrook, South Auckland  
 Postal: Private Bag 92121, Auckland, New Zealand  
 Telephone: (09) 3755 529 Auckland  
 (06) 2358 880 Whakatane  
 Fax: (09) 3755 859 Telen: 24836

# TEST CERTIFICATE

Ref: 3228/11222

CUSTOMER	Wilkinson	P3010ADIC01	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC065404
CUSTOMER Q/N	90-21N-528		PRODUCT	CRA WIDE COIL	PAGE	1 of 1
MILL Q/N	357274		DIMENSIONS	0.055" x 48" x CoR	DATE	08 April 2003

PACK NUMBER	CHEMICAL COMPOSITION PERCENT																	MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)					
	HEAT No	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N	CE	BEND 180°	YIELD	T.S.	%ELONG	HARDNESS	LENGTH (feet)
		x100				x1000										x10000	x100				G.L. =	HRB	
R9-404632-00	622644	4	TR	17	12	16												Good				47	1539
R9-404633-00	622644	4	TR	17	12	16												Good				47	1512
R9-404634-00	622652	4	TR	20	12	14												Good				50	1588
R9-404635-00	622652	4	TR	20	12	14												Good				50	1568
R9-404636-00	622652	4	TR	20	12	14												Good				48	1506
R9-404637-00	622652	4	TR	20	12	14												Good				48	1499

YIELD	GAUGE LENGTH (G.L.)			PLASTIC STRAIN RATIO (r)			IMPACT TEST			CARBON EQUIVALENT VALUE (CE)		
(A)=0.2% PROOF STRESS	(A)=200mm	(C)=60mm	(E)=2"	(A)=r0	(C)=45		(A)=10mm x 10mm	(C)=5mm x 5mm		(A)=C+Mn/8		
(B)=LOWER YIELD STRESS	(B)=60mm	(D)=5.65 / So	(F)=8"	(B)=r90	(D)=1r0/80+2/45 / 4		(B)=7.5mm x 10mm	(E)=5mm x 10mm		(B)=C+Mn/5+(Cr+V+Mo)/5+(Cu+N)/15	(C)=C+Mn/5+Si/24	(D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED  
 WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*  
 QC METALLURGIST

16 ga crms

2003 14:53 FAX 604 324 0075

WILKINSON STEEL

003

